

Date: Thursday, 12/13/2007 2:38:53 PM
 User: Kim Johnston

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE FITTING, FWD (OUTBOARD/INBOARD)
 Job Number : 36322
 Estimate Number : 10530
 P.O. Number :
 This Issue : 12/13/2007 S.O. No. :
 Prsht Rev. : NC Part Number : D2571
 First Issue : 1 / Type : MACHINED PARTS Drawing Number : D2571 REV E
 Previous Run : 35931 Drawing Revision : E
 Material :
 Due Date : 1/10/2008 Qty: 16 Um: Each
 Written By :
 Checked & Approved By : 07.12.13
 Comment : Est: 102.10.02 Re-format; Change to Dwg Rev. D & incorporated D2572 KJ

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 D6101007 7075-T7351 8.25X7.75X2.5



Comment: Qty.: 1.0000 Each(s)/Unit Total : 16.0000 Each(s)
 7075-T7351 8.25X7.75X2.5

Make from D6101-007 billet for D2571
 Ensure that grain is along 7.75" length
 Batch No: 034875

8F 08/01/14

2.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1

Program Batch No. 36322 Double check by: SK

1-Machine Step No 1 per Folio FA051 and inspect per attached Dimension Sheets
 2-Machine Step No 2 per Folio FA051 and inspect per attached Dimension Sheets
 3-Machine Step No 3 per Folio FA051 and inspect per attached Dimension Sheets
 4-Deburr and remove all machining marks
 5-Tumble to remove sharp edges.

PTB

DSP / BG / 2F 08/01/14

3.0 MILLING CONV. CONVENTIONAL MILLING MACHINE



Comment: CONVENTIONAL MILLING MACHINE

Machine keyway as per dwg D2571 & D2572

BG / DSP 08/01/20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

BG / DSP 08/01/20

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D2571 PAR #: 12/A Fault Category: Prod - macth NCR: Yes No DQA: 1 Date: 08.01.25
 QA: N/C Closed: 1 Date: 08 01 28

NCR: <u>36322</u>		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
08/01/14	2.0	Z origin was off by .125" . human error first time DAILY SADDLE set ups.	<u>[Signature]</u> 08/01/14	Scrap and Destroy and Replace Qty (x1) B# <u>34875</u>	<u>2.F</u> 08/01/14 <u>[Signature]</u>	<u>[Signature]</u> 08/01/14	<u>[Signature]</u> 08/01/14	<u>[Signature]</u> 08/01/14

NOTE: Date & initial all entries

Date: Thursday, 12/13/2007 2:38:53 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE FITTING, FWD (OUTBOARD/INBOARD)

Job Number: 36322

Part Number: D2571

Job Number:



Seq. #:

Machine Or Operation:

Description :

5.0

QC8

SECOND CHECK



Comment: SECOND CHECK

SA 08/07/22

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

MS

08-01-22

16

7.0

POWDER COATING

POWDER COATING



M 106379



16X

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

M-1

08/01/22

8.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT

AS MS

08-01-23

16X

9.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: ST432

AS

08/01/24

16X

10.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

08 01 25

Job Completion



W 2008/11/24

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD	Work Order:	36322
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	1	2	3	4	By	Date
A	0.438	0.443	DT8682	.441	.440	.440	.440		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		7.997	8.000	8.000	8.000		
F	0.490	0.510		.497	.510	.508	.505		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.501	.505	.505	.505		
J	1.174	1.184		1.180	1.179	1.179	1.179		
K	0.558	0.578		.569	.562	.562	.562		
L	1.174	1.184		1.180	1.179	1.179	1.179		
M	1.490	1.500		1.500	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.876	3.874	3.874	3.874		
P	0.115	0.135		.124	.127	.127	.127		
Q	0.115	0.135		.135	.135	.135	.135		
R	0.240	0.260		.248	.248	.248	.248		
S	0.115	0.135		.135	.130	.130	.130		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.961	2.960	2.960	2.960		
V	0.230	0.250		.240	.242	.242	.242		
W	0.115	0.135		.135	.122	.122	.122		
X	0.308	0.313		.312	.312	.312	.312		
Y	0.760	0.765		.764	.764	.764	.764		
Z	0.352	0.372		.367	.367	.367	.367		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.627	.635	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.384	1.385	1.385	1.385		
AF	0.115	0.135		.128	.128	.128	.128		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.252	.252	.252		
AI	2.000	2.020		2.000	2.001	2.001	2.001		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF 186
Date:	05/01/14

Audited by:	SD
Date:	08/10/12

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	36322
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

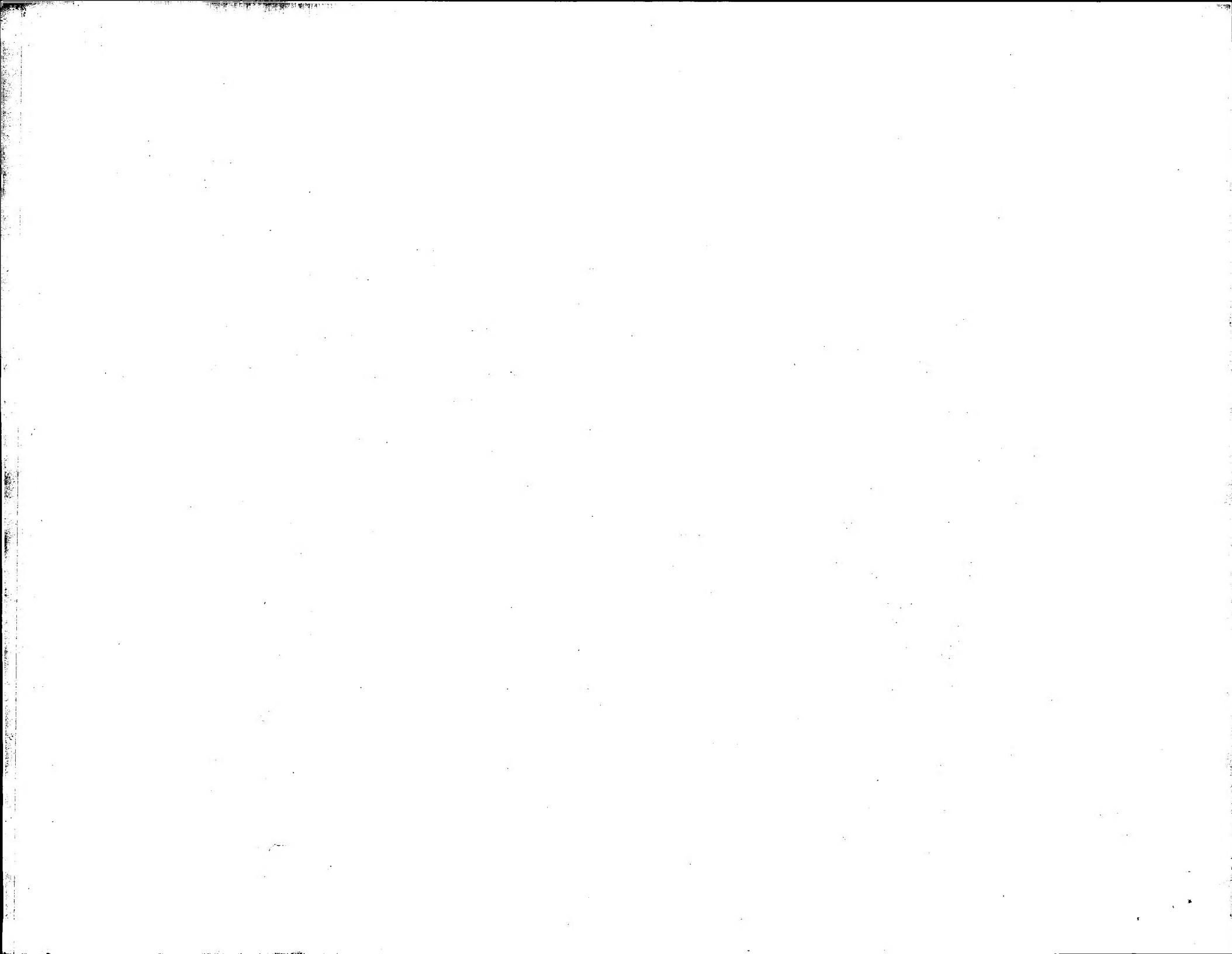
Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	5 th	6 th	7 th	8 th	By	Date
A	0.438	0.443	DT8682	.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.750	1.750		
E	7.990	8.010		8.002	8.002	8.007	8.002		
F	0.490	0.510		.501	.501	.501	.501		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.376	.376		
I	0.490	0.510		.500	.500	.503	.503		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.568	.568	.568	.568		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.500	1.500	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.125	.125		
Q	0.115	0.135		.125	.125	.135	.135		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.125	.125	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.960	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	.240	.240		
W	0.115	0.135		.128	.128	.126	.126		
X	0.308	0.313		.310	.310	.310	.310		
Y	0.760	0.765		.760	.760	.760	.760		
Z	0.352	0.372		.360	.360	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.630	.630	.630		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.125	.125	.125		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.260	.260		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by:	RF
Date:	08/01/17

Audited by:	08/01/22
Date:	SD

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	



DART AEROSPACE LTD	Work Order: 36322
Description: Saddle, Fwd Outboard	Part Number: D2571
Inspection Dwg: D2571 Rev. E	Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	91	102	113	124	By	Date
A	0.438	0.443	DT8682	.441	.441	.441	.441		
B	1.745	1.755		1.750	1.750	1.750	1.750		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.750	1.75	1.75		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		.502	.502	.502	.502		
G	0.257	0.262	DT8683	.258	.258	.258	.258		
H	0.375	0.380	DT8684	.376	.376	.377	.377		
I	0.490	0.510		.505	.505	.503	.503		
J	1.174	1.184		1.180	1.180	1.180	1.180		
K	0.558	0.578		.570	.570	.570	.570		
L	1.174	1.184		1.180	1.180	1.180	1.180		
M	1.490	1.500		1.495	1.495	1.495	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	.126	.126		
Q	0.115	0.135		.135	.135	.135	.130		
R	0.240	0.260		.250	.250	.250	.250		
S	0.115	0.135		.127	.127	.128	.128		
T	0.178	0.198		.188	.188	.188	.188		
U	2.940	2.980		2.962	2.962	2.963	2.963		
V	0.230	0.250		.238	.240	.243	.240		
W	0.115	0.135		.127	.127	.127	.127		
X	0.308	0.313		.310	.310	0.311	.311		
Y	0.760	0.765		.760	.760	0.760	0.760		
Z	0.352	0.372		.368	.364	.364	.364		
AA	0.470	0.530		.500	.500	.500	.500		
AB	0.615	0.635		.630	.620	.628	.628		
AC	0.053	0.073		.063	.063	.063	.063		
AD	0.240	0.260		.250	.250	.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		.125	.125	.128	.128		
AG	0.240	0.280		.260	.260	.260	.260		
AH	0.240	0.260		.250	.250	.254	.254		
AI	2.000	2.020		2.000	2.000	2.000	2.000		
AJ	0.023	0.043		.033	.033	.033	.033		
Accept/Reject									

Measured by: J.F. / DSP
Date: 08/01/19

Audited by: SD
Date: 08/01/20

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

DART AEROSPACE LTD	Work Order:	36322
Description: Saddle, Fwd Outboard	Part Number:	D2571
Inspection Dwg: D2571 Rev. E		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2571 Rev. E and record below:

				Recorded Actual Dimensions					
Dim	Min	Max	Go/No Go Gauge	13	14	15	16	By	Date
A	0.438	0.443	DT8682	.441	0.441	0.441	.441		
B	1.745	1.755		1.748	1.748	1.748	1.749		
C	3.495	3.505		3.500	3.500	3.500	3.500		
D	1.745	1.755		1.750	1.748	1.748	1.749		
E	7.990	8.010		8.000	8.000	8.000	8.000		
F	0.490	0.510		0.501	.501	0.501	0.499		
G	0.257	0.262	DT8683	.258	.260	0.260	.260		
H	0.375	0.380	DT8684	.376	0.377	0.377	.377		
I	0.490	0.510		.500	0.503	0.503	0.501		
J	1.174	1.184		1.180	1.180	1.1785	1.179		
K	0.558	0.578		0.568	0.568	0.568	0.568		
L	1.174	1.184		1.180	1.179	1.1785	1.179		
M	1.490	1.500		1.500	1.495	1.494	1.495		
N	2.495	2.505		2.500	2.500	2.500	2.500		
O	3.869	3.879		3.874	3.874	3.874	3.874		
P	0.115	0.135		.125	.125	0.126	0.128		
Q	0.115	0.135		.135	0.135	0.135	.135		
R	0.240	0.260		.250	0.247	0.247	0.247		
S	0.115	0.135		.130	0.130	0.130	.130		
T	0.178	0.198		.188	.188	.188	0.188		
U	2.940	2.980		2.962	2.960	2.960	2.960		
V	0.230	0.250		.240	.240	0.240	0.240		
W	0.115	0.135		.126	.126	0.126	0.126		
X	0.308	0.313		0.310	0.310	.310	0.310		
Y	0.760	0.765		.760	0.760	0.760	0.760		
Z	0.352	0.372		0.364	.364	0.364	0.364		
AA	0.470	0.530		.500	0.500	0.500	0.500		
AB	0.615	0.635		0.628	.628	0.628	0.628		
AC	0.053	0.073		.063	.063	0.063	.063		
AD	0.240	0.260		0.250	.250	0.250	.250		
AE	1.375	1.395		1.385	1.385	1.385	1.385		
AF	0.115	0.135		0.135	0.135	0.135	.135		
AG	0.240	0.280		.260	0.260	.260	.260		
AH	0.240	0.260		0.250	0.250	.250	.250		
AI	2.000	2.020		2.00	2.00	2.000	2.000		
AJ	0.023	0.043		0.033	.033	0.033	.033		
Accept/Reject									

Measured by:	S.F./DTP
Date:	08/01/18

Audited by:	SA
Date:	08/01/22




Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	02.09.24	Re-format; Added Rev. D	KJ	
C	02.10.11	Re-format; Added DT8682, DT8683, DT8684	KJ	
D	05.05.05	Added dimension AI	KJ/RF	
E	05.12.05	Added dimension AJ	KJ/JLM	

05.12.06

MATERIAL: 7075-T7351 (QQ-A-250/12) (REF DART SPEC. D6102-001)
FINISH: ACID ETCH, ALODINE PER DART QSI 005 4.1
POWDER COAT GLOSS WHITE (REF 4.3.5.1) PER DART
QSI 005 4.3
BREAK ALL SHARP EDGES 0.010 TO 0.020
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

- 1 ENGRAVE PART AND BATCH NUMBER IN THIS AREA TO MAX DEPTH OF 0.010
- 2 ENGRAVE DART LOGO TO MAX DEPTH OF 0.015 WITH MIN RAD 0.125
- 3 CHAMFER 0.063" x 45° AROUND THIS SURFACE (TYPICAL 2 PLACES)
- 4 CHAMFER 0.063" x 45° ALL AROUND
- 5 CHAMFER 0.033" x 45° (SEE DETAIL C)

 $\triangle E$

E	05.07.13	ADD CHAMFER ON RIDGE, NOTE 5
D	02.09.06	ADD RIDGES; TIGHTEN TOLERANCES
C	99.10.22	INCORP. DEO 9123/9079/9102 ADD DIMENSIONS PER TSR A1177
B	96.12.02	ADD GRAIN DIR., 0.438 WAS 0.425
A	96.09.16	NEW ISSUE
DESIGN		DRAWN BY
DS	PH	
DART AEROSPACE LTD.		HAMPSHIRE, ONTARIO, CANADA
CHECKED	APPROVED	DRAWING NO.
		D2571
DATE	TITLE	
05.07.13	OUTER FWD SADDLE	
REV. E		SCALE
SHEET 1 OF 1		2:3

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DETAIL C
SCALE 4:3

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NO. 26322